

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008187**Date Inspected:** 22-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Peng Guo/Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SMAW Process:

Welding of weld joint# 27 located on PCMK WD1 A305-77M-2. Welder is identified as 037780. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4113-1

Welding of weld joint# 23 located on PCMK WD1 A305-77M-2. Welder is identified as 068091. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4113-1

Welding of weld joint# 55 located on PCMK WD1 A305-77M-2. Welder is identified as 037932. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4113-1

Welding of weld joint# 47 located on PCMK WD1 A305-77M-2. Welder is identified as 066456. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-4113-1

Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SP 3013-001 026,028,030,032 009404 12 AE
038,040,042,044

2. CB 202F-009 002(A/B) NA NA

Bay# 5 - OBG Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 003 located on PCMK CB 202C-011. Welder is identified as 215248. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-L2c-S-2

FCAW Process:

Welding of weld joint# PP10 located on PCMK TR 2E. Welder is identified as 217185. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2231-TC-U4c-F

Welding of weld joint# PP8 located on PCMK TR 2D. Welder is identified as 250534. ZPMC QC is identified as Chen Shi Ming. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2231-TC-U4c-F

Bay# 11-Tower Assembly:

This QA Inspector randomly observed the following work in progress:

SAW Process:

Welding of weld joint# 81B located on PCMK ESTL3-4 B/K. Welder is identified as 041716. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S

Welding of weld joint# 81B located on PCMK ESTL3-4 B/K. Welder is identified as 042195. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S

Welding of weld joint# 81B located on PCMK ESTL3-4 B/K. Welder is identified as 040134. ZPMC QC is identified as Yuan Wen Jie. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-2221-C-U2b-S

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Welding of weld joint# 7B located on PCMK WD1 FDSA4-4 A/D. Welder is identified as 040772. ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2221-B-U3c-S-2

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
